



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-1
Job Sheet 162992



Part No: D3319-1

Job Qty: 2 ea

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 11/17/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Heliswiss Iberica SA (CHELI02)

Hangar 4, Lado Norte, Aeropuerto De Sabadell, Barcelona Sabadell, , 08205 Spain ph:011 34 93 720 6090
fx:34-937-100130.

Ship Via:

DWG Rev. D ✓

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Start up Operation	2 Ea		11/16/17	0.00	0.00	Start Up Small Fab	✓
100	Waterjet	2 pcs		11/16/17	0.00	0.21	Waterjet1	✓
110	QC	2 pcs		11/16/17	0.00	0.00	QC2	✓
120	QC	2 pcs		11/16/17	0.00	0.00	QC8	✓
140	Brake NC	2 pcs		11/16/17	0.07	0.14	Brake NC 1	✓
150	QC	2 pcs		11/16/17	0.00	0.00	QC5	✓
160	Autoweld 1	2 pcs		11/16/17	0.00	0.51	Automated welding	✓
170	QC	2 pcs		11/16/17	0.00	0.00	QC10	✓
180	QC	2 pcs		11/16/17	0.00	0.00	QC5	✓
190	SprayPaint	2 pcs		11/17/17	0.00	0.05	Spray Paint	NOV 09 2017
200	QC	2 pcs		11/17/17	0.00	0.00	QC3	✓
210	Packaging	2 pcs		11/17/17	0.00	0.00	Packaging3	NOV 17 2017
220	QC21-SA	2 Ea		11/17/17	0.00	0.00	QC21	✓

Don't Ask

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: _____ Prog Rev: _____ 2-Debur if necessary
Descriptions: 140 - 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: _____ 2- Form flat on press using DT8776 block
160 - 8259 HARDCOAT B: 138328
190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: 138637
210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S18GA	1	129	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches ± 0.030	5.010 4.950		
2	Wearplate	1.600inches ± 0.010	1.610 1.590		
3	Wearplate	2.660inches ± 0.010	2.670		

PQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-t
Part No. _____		Machir
NCR No. _____		Thermoform
Date : _____		Large
Step #: _____	QTY E	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Description Work Order Deviation

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/ ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incr ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐		

DART
AEROSPACE
S008669

**Forward Wearplate****D3319-1****PART NO:****Revision:****Operation:****Change No:**

Mfg Date: 11/10/17
Job No: 162992

ring ☐
ality ☐
ther ☐

Approval

ed By

Supervisor
rificationordinator
val

Wrong
mensions
er tolerance
rect
Missing
id

☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Finish
☐ Misread
☐ Turning Sequence

			2.650
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553
6	Wearplate	4.710inches $\pm$ 0.030	4.740 4.680
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090

Plex 11/6/17 1:06 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162992

Wednesday, October 04, 2017 11:10:51 AM

162992

Page 1

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 6/20/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan:  Date: OCT 04 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3319	D

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.18

FLOW CNC Waterjet

1-Cut as per Dwg D3319

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.04

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 162992

Wednesday, October 04, 2017 11:10:51 AM

162992

Page 2

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 6/20/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC	Form as per dwg NC BRAKE	0.07							
Brake NC	Memo	0.10							
	1- Form using DT8326 & DT8261 as per Dwg D3319Rev: _____ 2- Form flat on press using DT8776 block								
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.04							
160 *160* Large Fab	Weld per dwg A/R Hardcoat steel Batch: _____ Large Fab	0.00							
Large Fab	Memo	0.38							
	1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: _____								
	Qty Part Number Description Batch								
	A/R N/A 228/7560 Hardcoat Rod								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 162992

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162992

Page 3

Item ID: D3319-1**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop *NS2*****Item Name:** Forward Wearplate**Start Date:** 6/20/2017 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 7/3/2017 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.04

Quality Control

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 162992

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162992

Page 4

Item ID: D3319-1**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Forward Wearplate**Start Date:** 6/20/2017 **Start Qty:** 2.00 ***2*****Cust Item ID:****Required Date:** 7/3/2017 **Req'd Qty:** 2.00 ***2*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
200 QC Quality Control	Memo	0.02							
210	Identify as per dwg & Stock Location: _____ Packaging	0.00							
210 Packaging Packaging	Memo Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-1, B/N: BXXXXXXFor Product Eligibility see PDA05-18 and Stock Location: _____	0.02							
220	QC21- Final Inspection - Work Order Release	0.00							
220 QC Quality Control	Memo	0.20							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____		

Picklist Print

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Page 1

Work Order ID: 162992

162992

Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 6/20/2017

Required Date: 7/3/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM
17.08.29 AS PER DWG REV.D DD VERF:DP

IPP REV:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

sf

104.7199

1.4

M304S18GA

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

103.9159

M135779

7.02

M136036

4.65

M136568

12.6959

M136687

2.24

M136790

1.14

M137481

11.5

M137980

12.77

M138346

6.5

M138486

45.4

MAT20

0.804

M134580

0.804

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐																																																																															
Date : 17/11/17	Step #:	QTY Effective :		MRB (QSI042) Approval DAS 12 9-89 17/11/17																																																																													
Description Work Order Deviation		Disposition		Completed By AD NOV 09 2017 Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																													
Applying Axcelt adhesion promoter is time consuming. Testing by ENG indicated that Axcelt provides no noticeable improvement in adhesion of textured coating. Both hold equally well after several days submerged in water.		Acceptable to <u>not</u> use Axcelt adhesion promoter per QSI 005																																																																															
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Work Order Summary

Friday, November 10, 2017 9:58:14 AM

Page 1 of 2

Criteria : Work Order ID: 162992 Item ID: D3319-1 Product Family LARGE FAB
 Work Order Start Dates 6/20/2017 to 6/20/2017 11:59:59 PM Work Order Required Dates 7/3/2017 to 7/3/2017 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID	162992	Required Qty	2.0000	Status Code	Released
Item ID	D3319-1	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Forward Wearplate				
Current Acct Value	\$60.160				
Start Date	6/20/2017	Required Date	7/3/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$5.785	\$0.000	\$1.114	\$1.114	100.00%
Labor	\$40.961	\$0.000	\$12.721	\$12.721	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$94.009	\$0.000	\$28.222	\$28.222	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$140.755	\$0.000	\$42.057	\$42.057	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M304S18GA					
304/316 .050 Sheet	1.4000		9/28/2017	1.4000	\$5.785
Total Matl Amts:					\$5.785

Work Center Brake NC

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC01												
	7/4/2017											
140			0.25	0.03	3.25	0.41	8.00	\$0.672	\$8.734	\$19.093	\$0.000	\$28.499
	7/5/2017											
140			0.00	0.00	0.33	0.17	2.00	\$0.000	\$3.583	\$7.273	\$0.000	\$10.856
Total:			0.25	0.03	3.58	0.57	10.00	\$0.672	\$12.317	\$26.365	\$0.000	\$39.354

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
cris01												
	9/6/2017											
160			0.00	0.00	0.52	0.52	1.00	\$0.000	\$11.150	\$22.632	\$0.000	\$33.782

Total:	0.00	0.00	0.52	0.52	1.00	\$0.000	\$11.150	\$22.632	\$0.000	\$33.782
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Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
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conw01

6/23/2017

100			0.00	0.00	0.41	0.41	1.00	\$0.000	\$8.398	\$22.473	\$0.000	\$30.872
100			0.00	0.00	0.41	0.41	1.00	\$0.000	\$8.423	\$22.539	\$0.000	\$30.963
Total:			0.00	0.00	0.82	0.82	2.00	\$0.000	\$16.822	\$45.013	\$0.000	\$61.834

LOT TRACKING !!

Reason	Parent Item ID	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt	Last Cost Amt	Trans Type
162992	M304S18GA	-1.4	M136790	9/28/2017 1:50:19 PM	\$4.13	\$4.27	Issue